

## Work Order ID 53072



Page 1

October 22, 2009 2:26:42 PM

Item ID: D130-780-044

Accept



Setup

Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *09/10/22* Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
IIN-D130-780	B

100 0.00



DOCUMENT CONTROL

DC

Memo 0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-044 CHG 001

*N/A* *PL**10-07-14*

110 0.00



Pick Kit

Packaging

Memo 0.00

Packaging

*PL**10-07-14*

120 0.00



Small Fab Memo 0.00

Small Fab

ASSEMBLE PER DWG *13186**10/10/22**PL**10-07-22*

**Work Order ID 53072**

Page 2

October 22, 2009 2:26:42 PM

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

0.00



QC

Memo

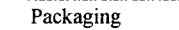
Quality Control

140

Pick Kit

0.00

0.00



Packaging

Memo

Packaging

150

QC4- 100% Inspect kits for completeness

0.00

0.00



QC

Quality Control

Memo

## Work Order ID 53072



Page 3

October 22, 2009 2:26:42 PM

Item ID: D130-780-044

Accept



Setup Start



Revision ID: B

Stop



Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Memo

0.00

PP 53060

Accepted 0

Packaging

Identify and pack for shipping as per PPP D130-780-044

Location: 160 53060 ~~160 53060~~ D130-780-042

PPP Rev: \_\_\_\_\_

Rev A

170



QC21- Final Inspection - Work Order Release

0.00

10/07/2009

QC

Memo

0.00

MF  
10-7-2009

Quality Control

# Picklist Print

October 22, 2009 2:26:46 PM

Page 1

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-4RevE		Manufactured		No		110	Each	0.0000	1.0000			
Spacepod Door, RH												
D2464-1250RevB		Manufactured		No		110	Each	0.0000	1.0000			
Neoprene Seal												
D3837-4RevB		Manufactured		No		110	Each	5.0000	1.0000			
Decal												

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

Loc Code

5

46233

5

110

Each

107.0000

2.0000

m57917

x1

ST

10 - 07 - 14

D2586RevD

Manufactured

No

## Warehouse

### Location

Main Warehouse

ST

Loc Qty

Loc Code

107

23082

0

45554

1

47183

6

50213

100

**Picklist Print**

Page 2

October 22, 2009 2:26:46 PM

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2585RevB



Manufactured

No

59116

110

Each

47.0000 2.0000

zt

10-07-14

Mounting Channel

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

4

45888

4

Main Warehouse

ST37

43

50544

4

51526

39

D2621RevB



Manufactured

No

B56526

110

Each

68.0000 2.0000

zt

10-07-14

Latch Plate, 350 Spacepod

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

68

46842

68

**Picklist Print**

Page 3

October 22, 2009 2:26:46 PM

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-15		Purchased	No			110	Each	180.0000	2.0000			

Screw

m114096



RT 10-07-14

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

ST	180
106903	3
108169	4
109321	4
111916	69
112794	100

NAS1149D0363J

Purchased

No

110 Each 2.0000 2.0000



RT 10-07-14

Washer

m115107

Warehouse      Loc Qty      Loc CodeLocation

## Main Warehouse

ST	2
112314	2

**Picklist Print**

Page 4

October 22, 2009 2:26:46 PM

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3



Purchased

No

110

Each

3,430.000 2.0000

2T 10-07-14

Nut

114523

Warehouse Loc Qty Loc CodeLocation

## Main Warehouse

ST	3430
110844	32
111274	35
111668	863
112314	2000
112385	500

D2857-1RevB



Manufactured

No

110

Each

18.0000 1.0000

2T 10-07-14

Hinge Bracket

57924

Warehouse Loc Qty Loc CodeLocation

## Main Warehouse

ST	18
41166	7
45788	5
50235	6

## Picklist Print

Page 5

October 22, 2009 2:26:46 PM

Work Order ID: 53072



**Parent Item:** D130-780-044RevA



**Parent Item Name:** Spacepod Door Assembly, RH

**Start Date:** 21/10/2009

**Required Date:** 04/11/2009

## Comments.

**Start Qty: 1.00**

Required Qty: 1.00

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October 22, 2009 2:26:46 PM

## Shop Packet Print

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Page 5





**Picklist Print**

Page 8

October 22, 2009 2:26:46 PM

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB 		Manufactured	No			110	Each	328.0000	1.0000		BT	10-07-14

Locknut

M5802

Warehouse      Loc Qty      Loc CodeLocation

Main Warehouse

ST      128

43758      26

44446      49

48238      53

Main Warehouse

ST59      200

51711      200

AN526C832R14

Purchased

No

Screw

D3015-3RevB 		Manufactured	No			110	Each	328.0000	1.0000		BT	10-07-14
-----------------	--	--------------	----	--	--	-----	------	----------	--------	--	----	----------

Warehouse      Loc Qty      Loc CodeLocation

Main Warehouse

ST      937

104916      937

# Picklist Print

October 22, 2009 2:26:46 PM

Page 9

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2589RevA



Manufactured

No

140

Each

61.0000

1.0000



Keys, Key Chain, 350 Hinge

B58194

10-7-238

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

61

46840

21

50378

40

D3552-7RevD



Manufactured

No

140

Each

12.0000

1.0000



Door Prop

B57731

10-7-238

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

12

52451

12

MS27039-08-11



Purchased

No

110

Each

78.0000

2.0000



Screw

8T

10-07-14

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

78

111977

78

**Picklist Print**

October 22, 2009 2:26:46 PM

Page 10

**Work Order ID:** 53072**Parent Item:** D130-780-044RevA**Parent Item Name:** Spacepod Door Assembly, RH**Start Date:** 21/10/2009**Required Date:** 04/11/2009**Comments:****Start Qty:** 1.00**Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149DN832J		Purchased	No			AD 140 110	Each	375.0000	4.0000			
---------------	--	-----------	----	--	--	------------	------	----------	--------	--	--	--

AD 140 110  
111268  
m 114 883

RT (0-07-14)

WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	375	
111193	3	
111359	72	
112385	300	

AD  
110

Each 490.0000 2.0000



RT (0-07-14)

NAS1515H3

Purchased

No

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST	490	
109268	259	
110397	87	
111268	144	

X2

Washer

**Picklist Print**

October 22, 2009 2:26:47 PM

Page 11

Work Order ID: 53072



Parent Item: D130-780-044RevA



Parent Item Name: Spacepod Door Assembly, RH

Start Date: 21/10/2009

Required Date: 04/11/2009

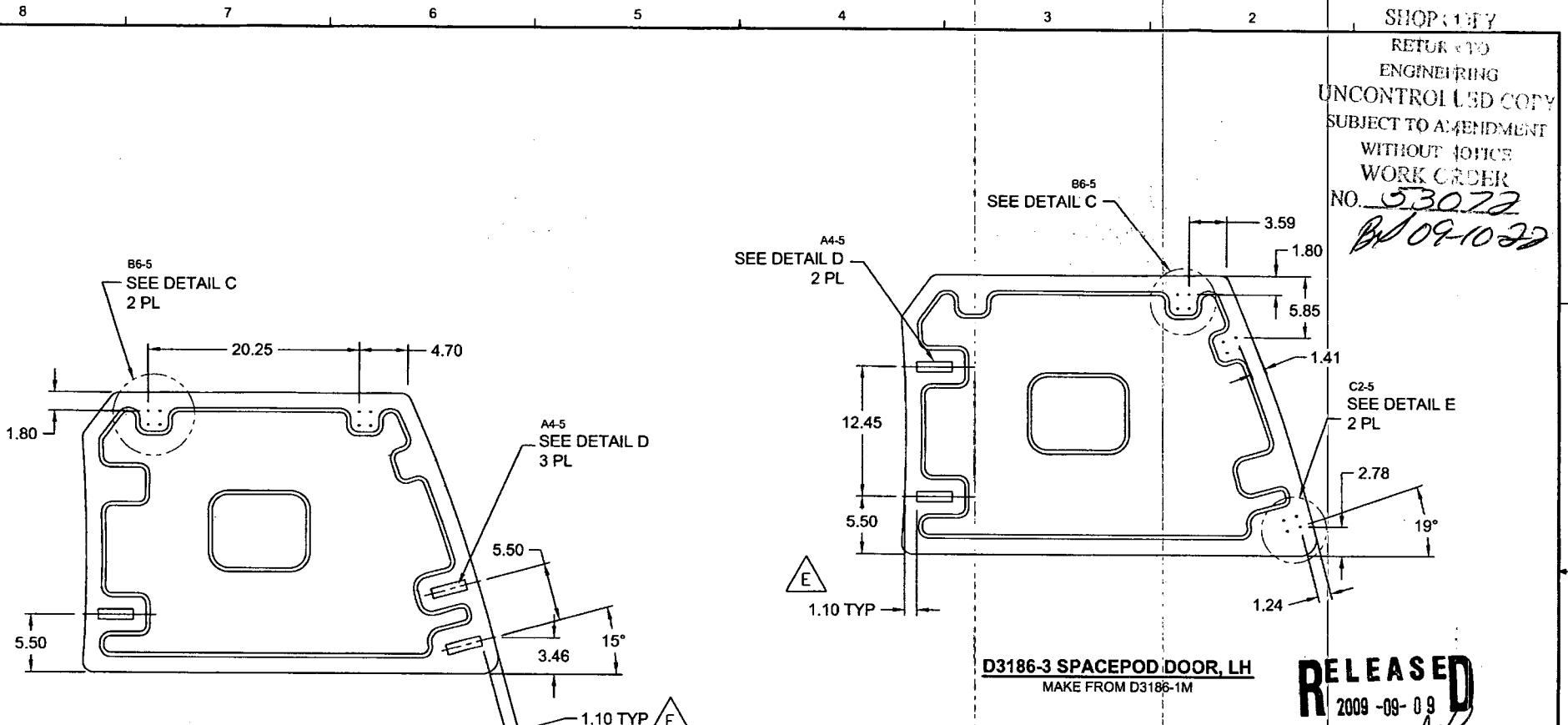
Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08  Nut		Purchased	No			AD 100 P10	Each	407.0000	2.0000		ET	10-07-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
<b>Main Warehouse</b>		
ST	407	
110002	24	
111889	51	
112243	47	
112492	85	
112612	100	
112794	100	

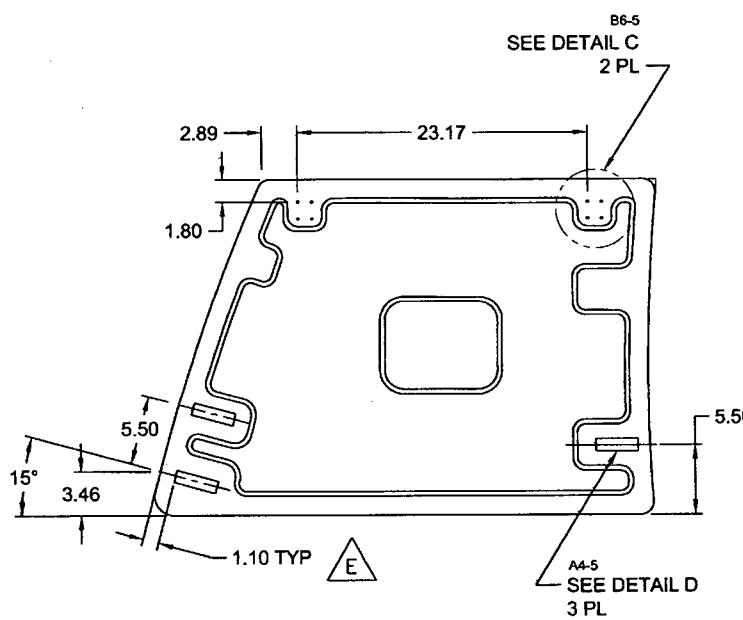


D3186-1 SPACEPOD DOOR, LH  
MAKE FROM D3186-1M

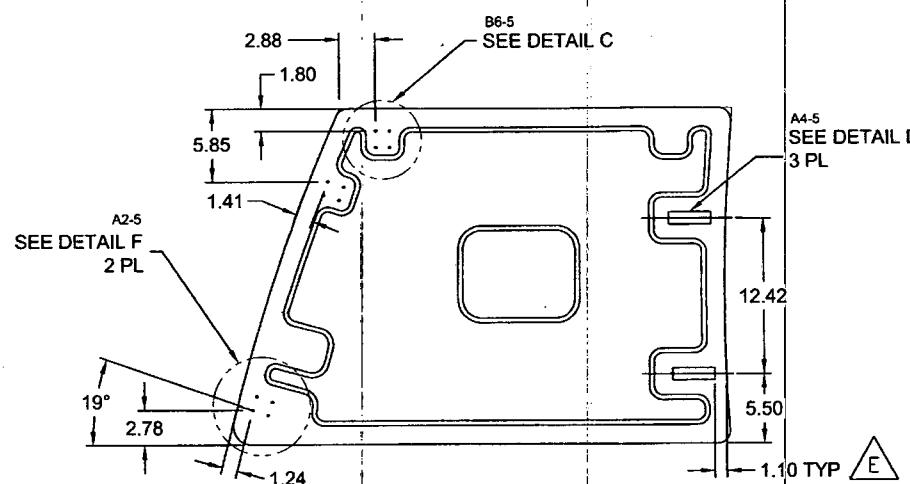
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026			RF	09.07.08
D	UPDATE DIMENSIONS			LE	07.02.22
C	REMOVED D0600-XXX LABELS			LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED			LE	06.09.25
A	NEW ISSUE			CP	03.03.27
REV.	DESCRIPTION			BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	<i>IP</i>	DRAWING NO.	REV. E		
MFG. APPR.	<i>IP</i>	D3186	SHEET 1 OF 5		
APPROVED	<i>IP</i>	TITLE	SCALE		
DE APPR.	<i>IP</i>	SPACEPOD DOOR	NTS		
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

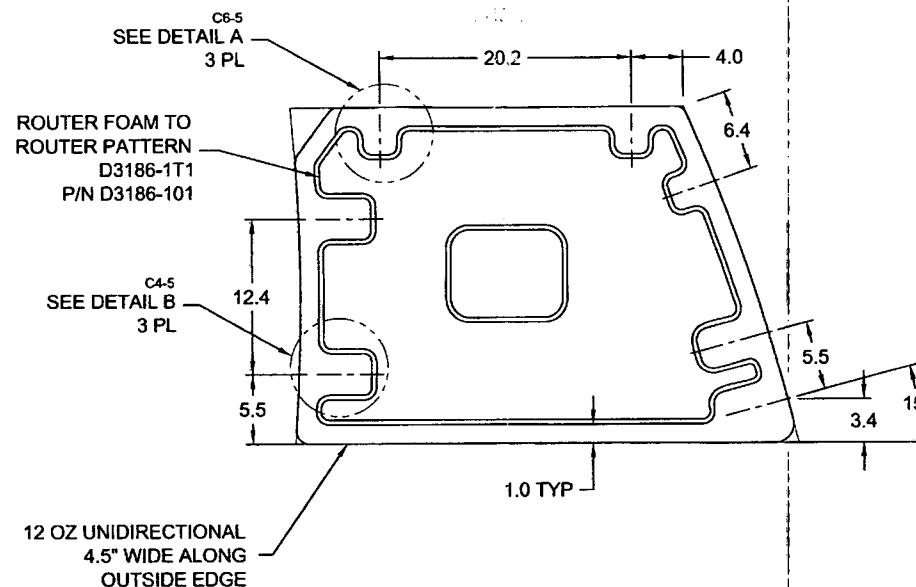
**RELEASED**  
2009-09-09

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARE EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MM	DRAWING NO.	REV. E
MFG. APPR.	MM	D3186	SHEET 2 OF 5
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

D3186-1M SPACEPOD DOOR AS MOLDEDNOTES:

- 1) MATERIAL:
  - 1) RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
  - 2) FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL
  - 3) FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
  - 4) 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
  - 5) LAMINATE PER DART QSI 006 4.0
  - 6) LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8005 FOR DOOR LAYUP

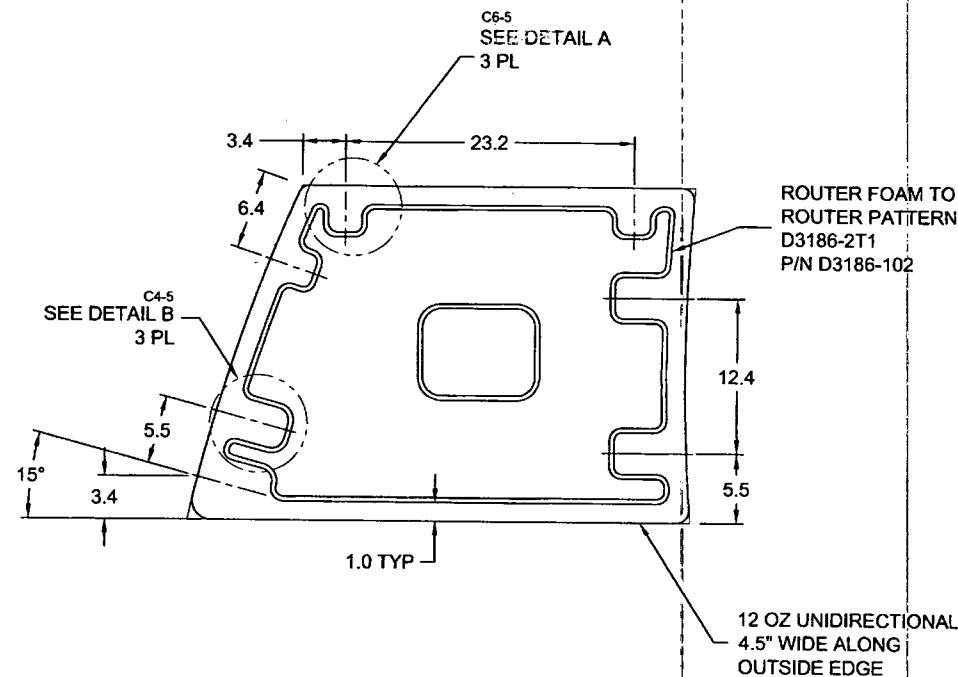
RELEASED  
2008-09-08  
W

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.	W	D3186	SHEET 3 OF 5
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

MAIN LAYUP  
 9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY



D3186-2M SPACEPOD DOOR AS MOLDED

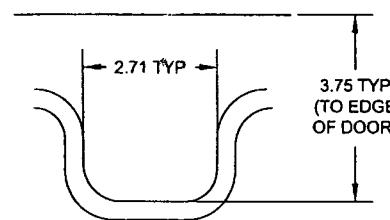
NOTES:

- 1) MATERIAL:  
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

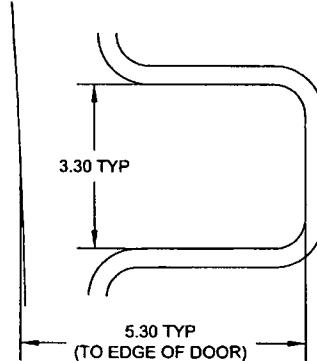
RELEASED  
 2009-08-09  
*[Signature]*

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS    NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT    WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

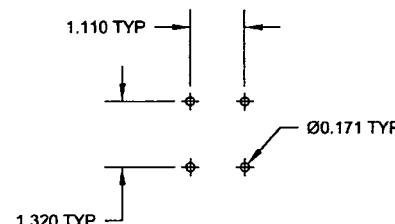
53072



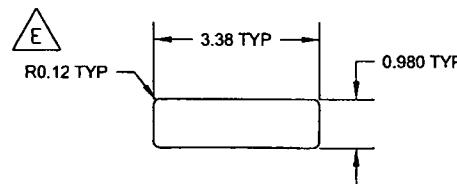
**DETAIL A** D6-3  
SCALE 4X D4-4



**DETAIL B** C6-3  
SCALE 4X C6-4

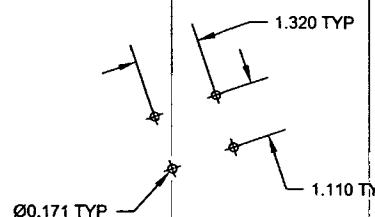


**DETAIL C** D7-1  
D3-1  
D6-2  
D3-2  
SCALE 4X

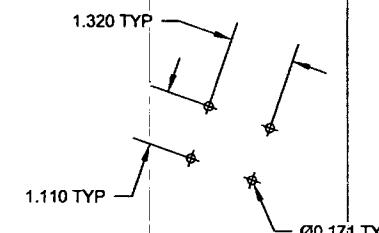


**DETAIL D** C5-1  
D4-1  
B6-2  
C2-2  
SCALE 4X

NOTE: ENSURE THAT CUTOUT IS  
PERPENDICULAR TO EDGE OF DOOR



**DETAIL E** C1-1  
SCALE 4X



**DETAIL F** C4-2  
SCALE 4X

RELEASED  
2009-09-09

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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